



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6795635-2A
Job Sheet 169117



Part No: RB6795635-2A

Job Qty: 1 ea

Part Name: Socket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/1/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB6795635 Rev3 IPP Rev A IPP Rev A 17.11.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/17	0.00	0.00	Start Up Machining-3		17-12-8
110	CNC Lathe	1 pcs		12/8/17	0.00	0.25	MORI SL-154		17
120	QC	1 pcs		12/8/17	0.00	0.00	QC2 Machining-4		17
130	QC	1 pcs		12/8/17	0.00	0.00	QC8 Machining-4		17/12/10
140	Outsource	1 pcs		12/8/17			GRO002-VC	10	18-01-8
150	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging2		18-01-8
160	QC	1 pcs		12/8/17	0.00	0.00	QC6		38
210	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging3-1		17
220	QC21-SA	1 Ea		12/8/17	0.00	0.00	QC21		17

Part Op 90 -

Descriptions: 110 - 1-Machine as per DWG. FB688 FOLIO REV: _____ DWG REV: _____ 2-Deburr

140 - 1--Issue P/O to Metcore ; P/O _____ RC 36-40 2-Bead blast 3- Certificate of Conformity is required

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M4140H-R1 750	0	5	0	0

3000805
*F4138616-0 .46

Part Specifications

Specifications could not be found.

Plex 12/1/17 10:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		

Mfg Date: 01/08/18
 Job No: 169117

Outsource

PART NO:
Revision:
Operation:
Change No:

RB6795635 - 2A

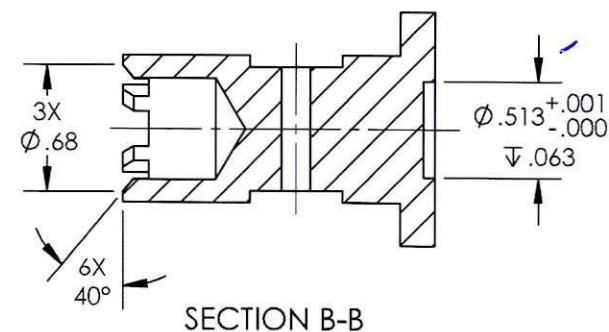
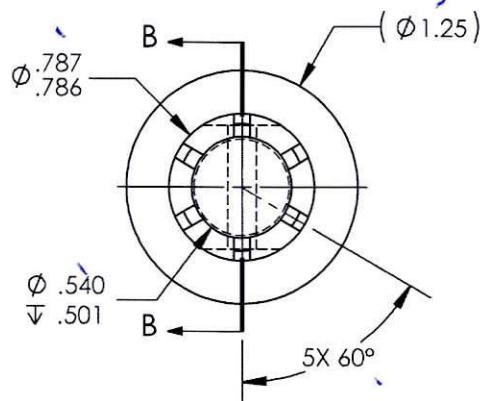
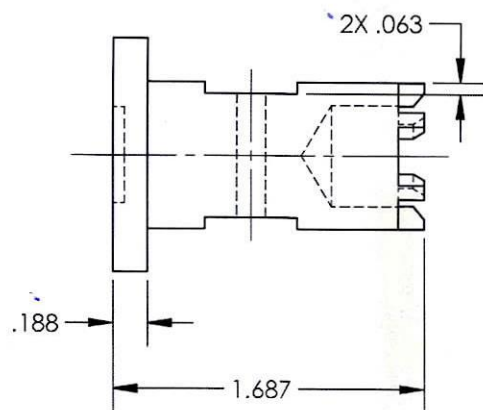
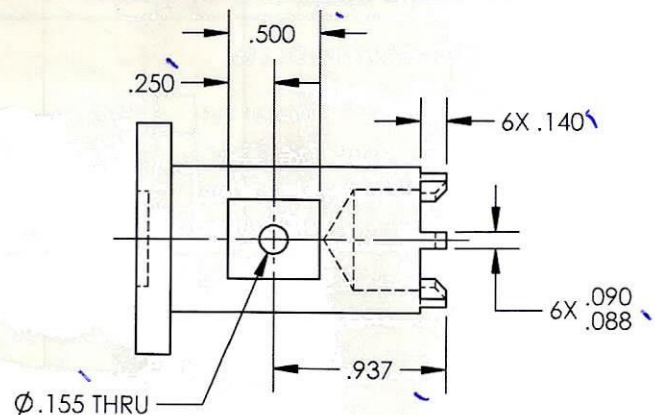


Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			
Environment ☐	☐	No Re-verification	☐
Design ☐	☐	Operator	☐
Doc/Data ☐	☐	Offset/Setup	☐
Equip/Tooling ☐	☐	Supplier	☐
Handling/Pre ☐	☐	Training	☐
Material ☐	☐	Use for Testing	☐
Internal Transport ☐	☐	Poor Information	☐
Tribal Knowledge ☐	☐	Rushing	☐
LOA ☐	☐	Product Improvement	☐
Substation ☐	☐	Process Improvement	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐
Misidentified ☐	☐	Past Due	☐
			OTHER : ☐

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	15-0066	-2A CHD DIM WAS Ø1.250 IS (1.25).			3/26/2015	RJC JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 169099 HJS
1091177-11-30



(-2A)

SOCKET

DART AEROSPACE	
TITLE WRENCH-INSTALLATION AND REMOVAL, GAS PRODUCER TURBINE TIE BOLT NUT	
DWG NO. RB6795635-2A	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 36-40
.XX ± .01 ANGLES ± 5°	FINISH SEE -2
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE NOTE SHT 1
SCALE 1:1	DATE 8/15/2007
SHEET 4 OF 5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																																																																							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038630

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO038630

PO Date: 12/12/17

Due Date: 12/22/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
DEC 21 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168814	RBW6705G02331-3G	Rigging Pin Assembly N4 1--Issue P/O to Metcore ; P/O _____ RC: 26-30 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER To ship directly to Groupe Altech	Firmed	12/19/17	1 pcs	0 pcs	1 pcs	\$294.00/pcs	\$294.00
Line Item Note part made from O1 tool steel										
2	169117	RB6795635-2A	Socket 1--Issue P/O to Metcore ; P/O _____ RC 36-40 2-Bead blast 3- Certificate of Conformity is required	Firmed	12/19/17	2 pcs	0 pcs	2 pcs	\$147.00/pcs	\$294.00
Line Item Note part mmade from 4140H										

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

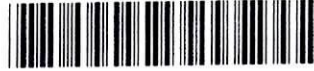
Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
324019	1	124646

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
38630		4140	2017/12/14	fedex
QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

2 RB6795635-2A
(2) RB6795635-2A JOB. 169117

1 SAC DE PLASTIQU

SP 18-01-8'

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
SAC DE PLASTIQU	1	

certificat

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 2
POIDS EXPÉDIÉ / Weight Shipped : 0,45
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVE

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped :	2
POIDS EXPÉDIÉ / Weight Shipped :	0,45

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2017/12/22

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél : 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
324019	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
38630	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	36 - 40 HRC	2	37 - 38 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
2	0,45	RB6795635-2A (2) RB6795635-2A JOB. 169117 1 SAC DE PLASTIQUE

SP18-01-8

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2017-12-21

Pierre Piché
Chief Inspector



APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
324019	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

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2	0.45	RB6795635-2A (2) RB6795635-2A JOB. 169117 1 SAC DE PLASTIQU		

COMMENTAIRES / comments

SALT HARDEN 1600F, 40 MIN
SALT HARDEN 1600F, 40 MIN
TEMPER 800F, 2HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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Isabel

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